

Work Order ID 161471

Tuesday, May 16, 2017 2:28:20 PM

161471

Page 1

Item ID: D2153 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Prop
Start Date: 5/16/2017 Start Qty: 36.00 ***36*** Cust Item ID:
Required Date: 5/30/2017 Req'd Qty: 36.00 ***36*** Customer:
Reference: SCHEUDLED

Approvals: Process Plan: DAS 21 9-89 Date: MAY 16 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2153	Rev A1

100

0.00

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 36392 Gas Spring P/N: SL13-10 (10lb) Possible
supplier: Spring Lift Corporation **Note: Do not ship by air** Allow an
extra 7 to 10 business days for shipping **Material release note is required

0.00

36MAY 19 2017DAS
13
9-89

110

0.00

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure Material Release Note is attached

0.72

36x SP176-7

120

0.00

120

QC

Quality Control

QC6- All purchased or subcontracted products

Memo

Inspect Test Spring is 10lb

0.00

36DAS
38
3-89
JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.36							
Quality Control									


JUL 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Tuesday, May 16, 2017 2:28:23 PM

Page 1

Work Order ID: 161471

Parent Item: D2153

Parent Item Name: Door Prop

Start Date: 5/16/2017

Required Date: 5/30/2017

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SL69-BS Ball Stud		Purchased	No			100	Each	83.0000	2	72	DAS 30 9-89		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		83							
				M135261		5							
				M137196		78							
D2153P Door Prop		Purchased	No			130	Each	0.0000	1	36			
D3015-3 Locknut		Manufactured	No			130	Each	52.0000	2	72			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FG		18							
				95758		8							
				96151		10							
				ST015		34							
				158471		34							
NAS1149D0563J Washer		Purchased	No			130	Each	721.0000	2	72	DAS 30 9-89		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		110							
				m135774		110							
				ST263		611							
				m137361		611							

JUL 05 2017

JUL 05 2017

JUL 05 2017

DQA: _____ Date: _____



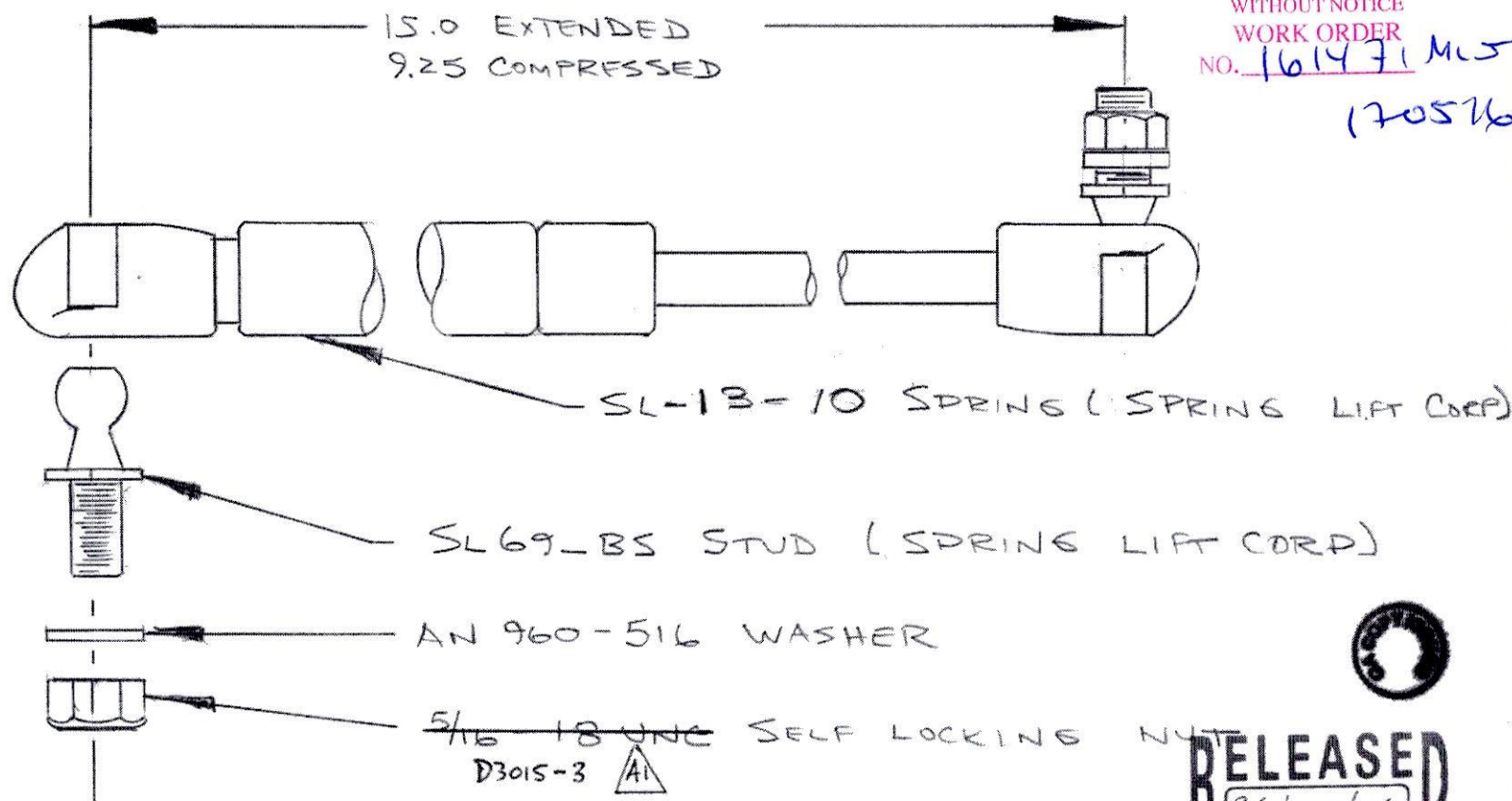
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OTHER : ☐																									

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161471 MJS
170576



RELEASED
96/07/16

01.05.01 CHANGE TO D3015-3 SL 13-10 WAS SL 32-15		A1 A A	REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523 BASIC CODE DIA. DASH NO. H-HEAD NEAR SIDE F-HEAD FAR SIDE D-DIMPLE DASH NO. OF SHEETS C-COUNTERSINK LENGTH DASH NO. W-SPOTWELD BASIC CODES B-M120470AD B-M120476AD	PART NO. CONTRACT NO. DRAWN HATTON DATE 07.28.92 DESIGN HATTON STRESS CHECKED 07/28/92 CLIENT	DESCRIPTION GAS SPRING ASSEMBLY	MATERIAL DART DART AERO ACCESSORIES INC. VANCOUVER CANADA	SPEC./VENDOR DZ153	
			REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL. S. 7742 5. HOLES PER AND 10387	LIMITS 1. TOLERANCES — .XX & .030 .XX & .010 2. ANGLES 1 W 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005				TITLE GAS SPRING ASSEMBLY	CODE DZ153	REV A
REPORT ALL DISCREPANCIES — DO NOT SCALE										

DZ153

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OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36392

Purchase Order Date 5/19/2017 2:23:37 PM

PO Print Date 5/19/2017

Page Number 1 of 2

Order From :
ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

VU-ATT001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Contact Name
Vendor Phone 616-897-2285
Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D2153P	Door Prop	6/2/2017 Yes 6/2/2017		36.00 Each	\$13.05	\$469.80
	AS PER DWG D2153 REV. A B161471 ATTWOOD P/N: SL13-10 (10LB)						

Line Total: \$469.80

3	71401-45	PROCUREMENT QUALITY CLAUSES	6/2/2017 No 6/2/2017		1.00	\$0.00	\$0.00
	Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A043 retention of quality documents						

DAS
38
9-89

SP 7-6-7

Line Total: \$0.00

Note:

5/19/2017



MotorGuide
NEVER STOP.

CUY: 68510 M57: 05176-00

*COLLECT

131794240

PRO NO: 00067

SHIP VIA: FEDEX GROUND

EDL: 00226970006072461

FREIGHT: _____

ATTWOOD CORP

49301-0200

INCOTERMS: EXW SHIPPER DOOR

1.00 0.00 1.19

FROM: 208: 001272

DATE: 06/05/17

OPOR: 9

LABEL NO:

ATTWOOD CORP

QTY	UNIT	LA	IP-18 / CPC	DESCRIPTION / SKU	LA	G/S WGT
1	EA	001272	✓	SP 68580 18" 7.10 1 W BL	90	1.2

SP17-6-7

Track: 584946097885

Mode: FedEx Ground Gr	Act Wgt:	11.75	Shipping:	26.49
Invoice: 000002269702	Dim Wgt:	12.00	Special:	6.19
Customer: 68580	DV:	469.80	Handling:	0.00
Date: 06/05/2017	COD:	0.00	Total:	32.68

DAS
38
9-89



15179:3240

00967

SHIP VIA: FEDEX GROUND

601.1 00226970006072461

FREIGHT:

INCOTERMS: EXW SHIPPER DOCK

SPUR: 9

LABEL NO :

0190

LN QTY WGT

LN	QTY	WGT	DESCRIPTION / ERU	UNIT# / JFC
1	36	12	GE SPRING 13" EX10 LG# BL	SL12-10-1

88 17-67.

DAS
38
9-89

10. *Journal of the American Medical Association*, 1997; 277: 1033-1038.

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